

77739

Tuesday, December 20, 2011 8:01:30 AM

N900040100

Setup Start *NS1*

Stop *NS2*

6

6

Reference:

11-12-20

Run Start *NR1*

Stop ***NR2***

100	BAND SAW	0.00			
100					
Bandsaw	Memo	0.00	<i>FK</i>	<i>11/12/20</i>	<i>6</i>
Jeaspa Bandsaw	Cut blanks: (1.250" x 1.500") x 3.60" long				
110	HAAS CNC VERTICAL MACHINING #1	0.00			
110					
HAAS 1	Memo	0.00	<i>FK</i>	<i>11/12/20</i>	<i>6</i>
HAAS CNC vertical machine #1	1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-32-Deburr				
120	QC2- Inspect parts off machine FAI/FAIB	0.00			
120					
QC	Memo	0.00	<i>FK</i>	<i>11/12/20</i>	<i>6</i>
Quality Control					

Work Order ID 77739

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Tuesday, December 20, 2011 8:01:30 AM

Item ID: D3195-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 12/20/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 12/22/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		11-12-21		6			
--	---	--------------	--	----------	--	---	--	--	--

140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				6			6/11-12-20
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150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo	0.00 0.00							
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M 118489

START TIME: 1:45
 FINISH TIME: 2:15
 OVEN TEMPERATURE: 3200F

6X 6/11-12-21

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Tuesday, December 20, 2011 8:01:30 AM

Item ID: D3195-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 12/20/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 12/22/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Small Fab	0.00							
170									
Small Fab	Memo	0.00							
Small Fab	1-Lightly Sand bonding surface2-Bond D3195-7 into D3195-13as per Dwg D3195A/RContact Cement								
	OR 3K 1300/1300L								
	M119597								
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									

6 BL 11-12-21

11/12/22 (6)

11/12/22

Work Order ID 77739***77739***

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Tuesday, December 20, 2011 8:01:30 AM

Item ID: D3195-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket Assembly
Start Date: 12/20/2011 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 12/22/2011 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: 2Y6A Memo	0.00 0.00				11/12/22	5	(60)	
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/12/22	MF 11-12-22

Picklist Print

Tuesday, December 20, 2011 8:01:30 AM

Page 1

Work Order ID: 77739

Parent Item: D3195-043

Parent Item Name: Bracket Assembly

Start Date: 12/20/2011

Required Date: 12/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3195-7 Pad		Manufactured	No			100	Each	10.0000	1	6		11/12/22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		10							
				73040		10							
M6061T6B1.500X01.250 6061-T6 Bar 1.50 x 1.25		Purchased	No			170	f	22.2120	0.3	1.8947368			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT003		22.212							
				118071		0.112							
				119513		22.1							
										1.895	FK 11/12/20		

DART AEROSPACE LTD		Work Order:	77739
Description: Bracket		Part Number:	D3195-3
Inspection Dwg: D3195 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.432	+/-0.010	3.432	✓		FK-04	Vern
1.265	+/-0.010	1.260	✓		"	"
R0.37	+/-0.030	.37	✓		rad gauge	
Ø0.277	+0.005/-0.000	.277	✓		FK-04	Vern
2.677	+/-0.005	2.677	✓		"	"
0.242	+/-0.010	.243	✓		"	"
0.377	+/-0.010	.377	✓		"	"
0.500	+/-0.010	.500	✓		"	"
R0.188	+/-0.010	.188	✓		rad gauge	
0.250	+/-0.010	.249	✓		FK-04	Vern
0.882	+/-0.010	.882	✓		"	"
1.250	+/-0.010	1.250	✓		"	"
0.500	+/-0.010	.498	✓		"	"
Ø0.191	+0.005/-0.000	.191	✓		"	"
1.000	+/-0.010	1.000	✓		"	"

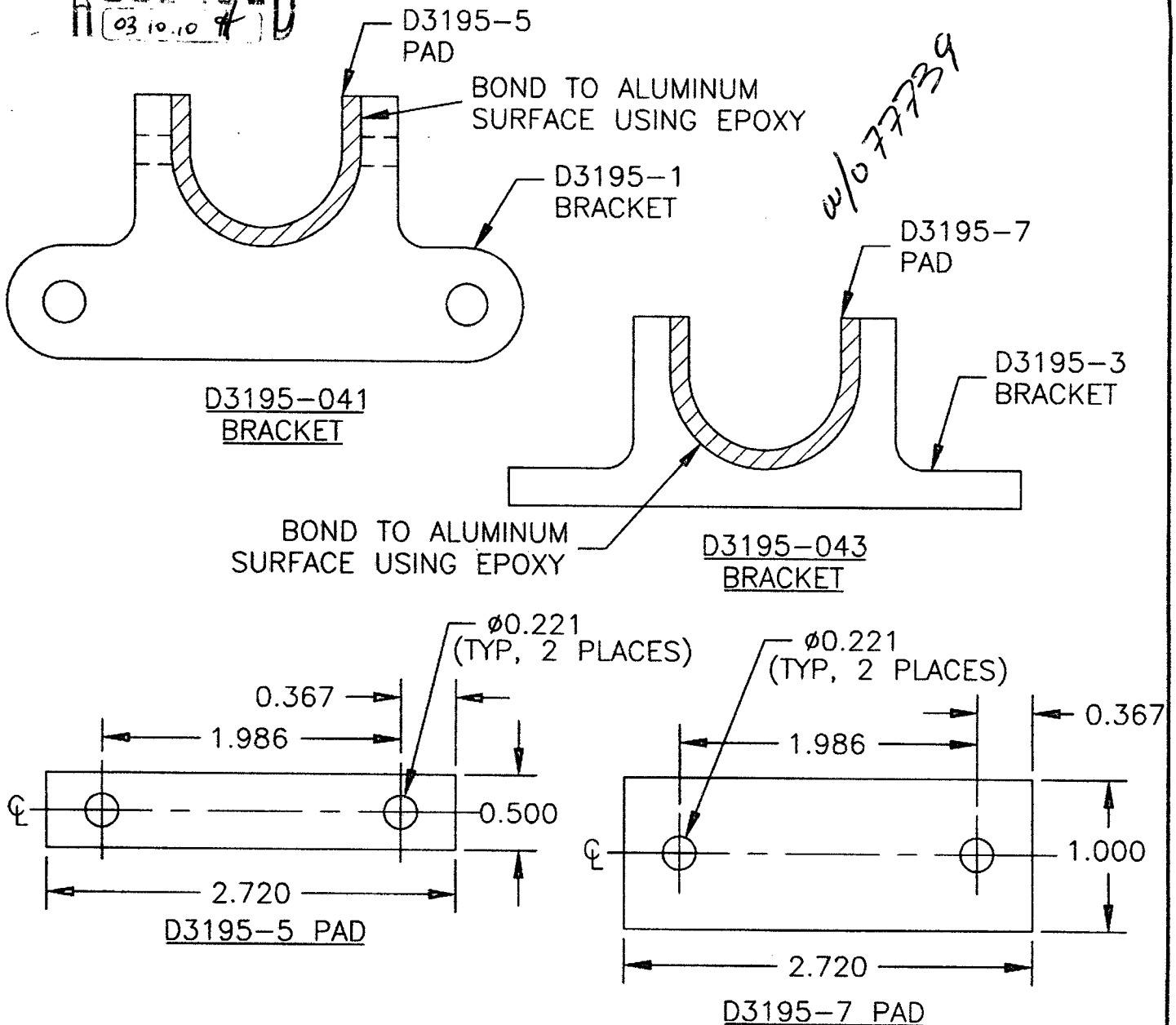
Measured by:	FK	Audited by:	SL	Prototype Approval:	N/A
Date:	11/12/20	Date:	11-12-21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-013)	KJ/RF	
B	05.04.26	R0.37 was R0.037; 1.084 removed	KJ/JLM	



DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D3195 REV. A SHEET 1 OF 3
DATE	03.06.23	TITLE	BRACKET	SCALE 1:1
A	03.06.23	NEW ISSUE		

RELEASED
R 03.10.10 #



D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

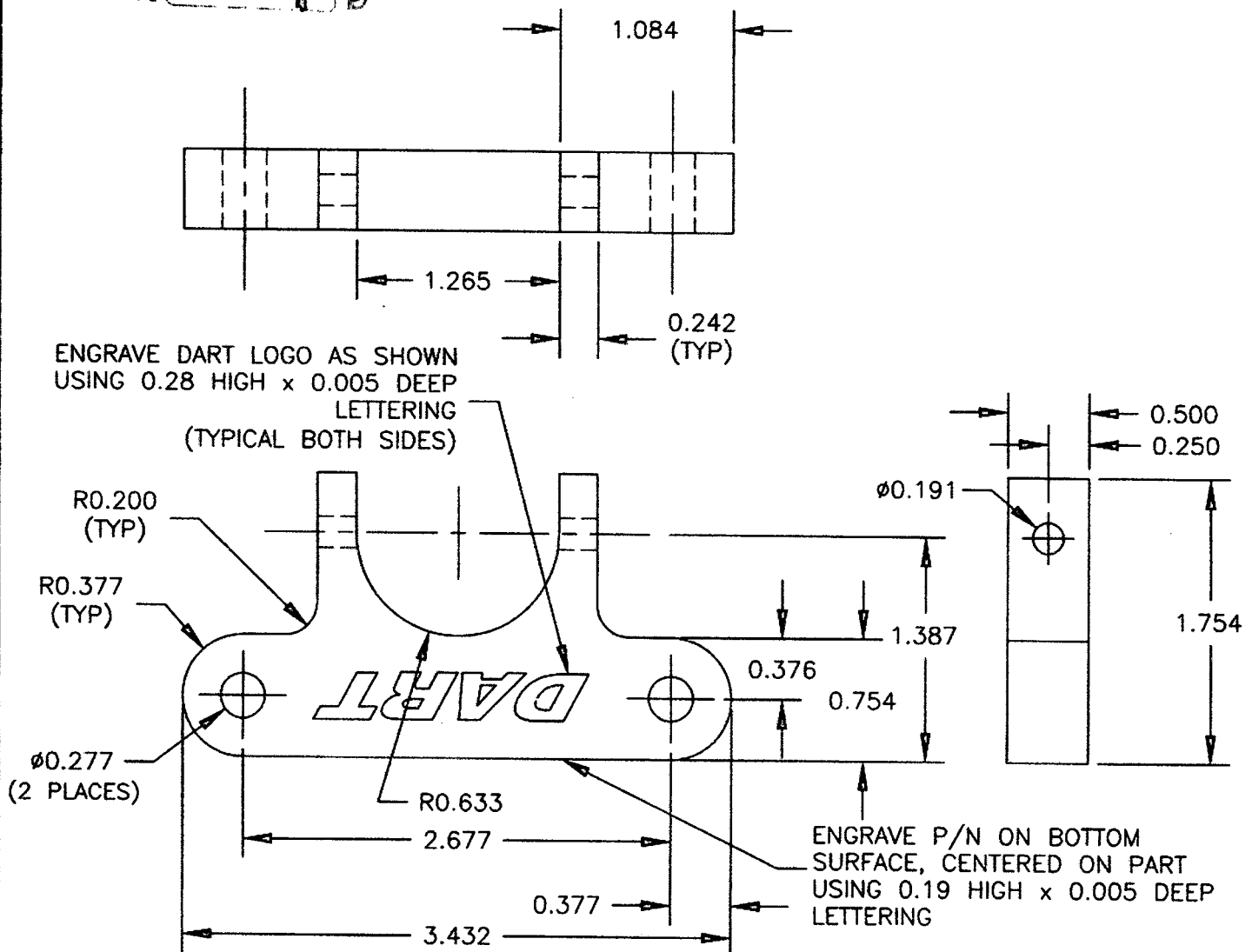
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3195	REV. A SHEET 2 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1

RELEASED
03.10.10



w/6 77739

D3195-1 BRACKET

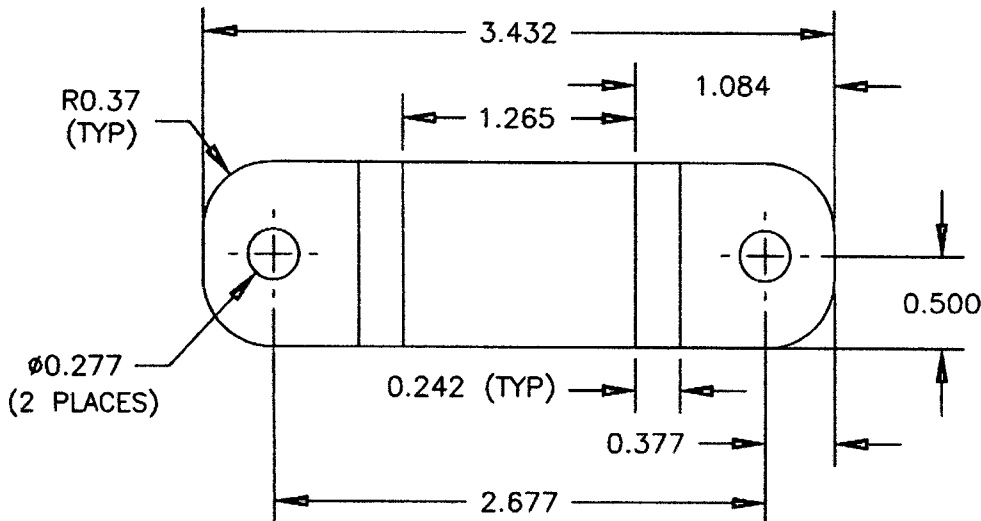
- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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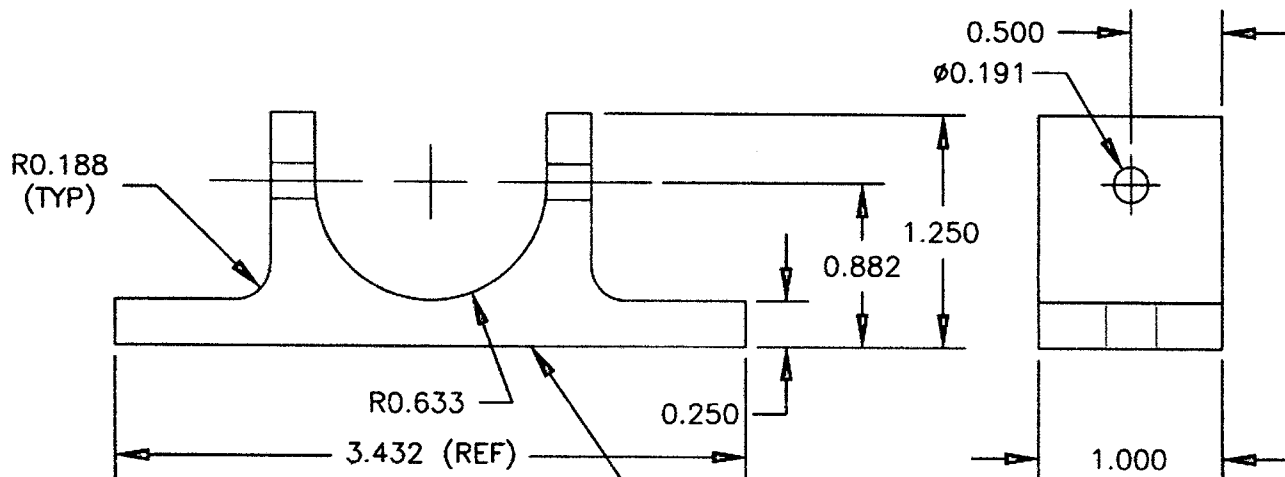
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



w/o 77739



RELEASED
03.0.10

ENGRAVE P/N ON BOTTOM
SURFACE, CENTERED ON PART
USING 0.19 HIGH x 0.005 DEEP
LETTERING

D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
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